

Work Order ID 83527

83527

Page 1

April-19-12 11:18:13 AM

Item ID: D3781-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Supporting Plate

Stop ***NS2***

Start Date: 19/04/2012 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12/04/19

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3781

Rev E

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3781-1

Dwg Rev: E

Prog Rev: E

2- Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

4/5

0

Jan 12-6-19

4

0

Jan 12-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83527

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 19/04/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 03/05/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

817/ae/19

x4

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

1-counter sink holes as per dwg D3781
2- deburr if necessary

4x

12/06/19

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

8/2/66/19

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 83527

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Item ID: D3781-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Supporting Plate

Start Date: 19/04/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00				4		26/12-20	
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				4		12/06/20	
Quality Control									
170		0.00							
170									
Small Fab	Memo	0.00				4		12/06/20	
Small Fab	1- assemble nut plate as per dwg								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83527

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Page 4

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Cust Item ID:

Required Date: 03/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: 062

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

(44)

4

12/06/2012

12/6/21

MCS 12/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-19-12 11:18:16 AM

Page 1

Work Order ID: 83527

83527

Parent Item: D3781-1

D3781-1

Parent Item Name: Supporting Plate

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: revD as per dwg DD verified by:EC
as per dwg RevE DD 10.04.27 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

100

sf

558.1500

0.1062

0.447158

**

M6061T6S 080

6061-T6 .080 Sheet

Jun 12-6-19

Location

Loc Qty

Loc Code

MAT021

558.15

117285

2.15

119766

39.77

120096

312.83

120349

11.4

121193

192

MS20426AD3-3

Purchased

No

170

Each

3,737.000

4

16

**

MS20426AD3-3

Rivet

Location

Loc Qty

Loc Code

ST316

3737

119109

655

121011

2647

19099

435

MS21075L3

Purchased

No

170

Each

145.0000

2

8

**

MS21075L 3

Nutplate

Location

Loc Qty

Loc Code

GA

88

121090

88

ST303

57

120910

57

EP 12/06/20

16

EP 12/06/20

8

Dart Aerospace Ltd

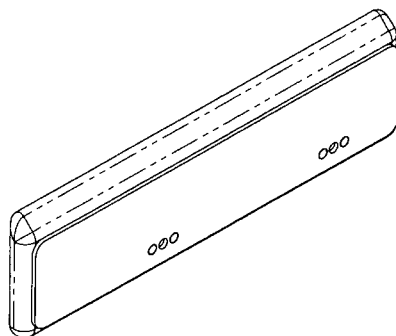
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

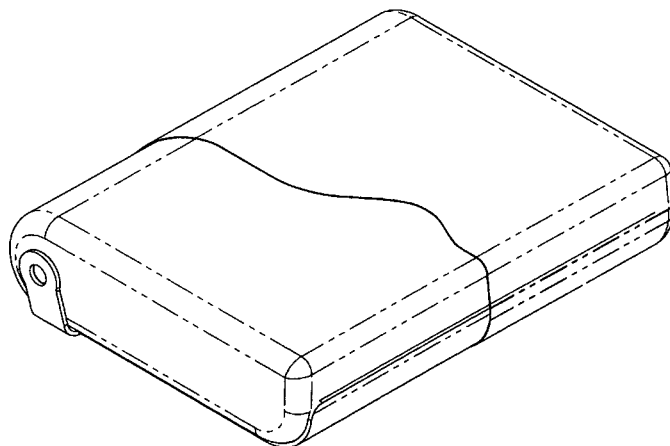
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3781-041 LATERAL CUSHION ASSY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)



D3781-043 ARMREST CUSHION
(UPHOLSTERY FABRIC NOT SHOWN PARTIALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83527 MLJ

12/04/19

RELEASED
2010-04-26
MLJ

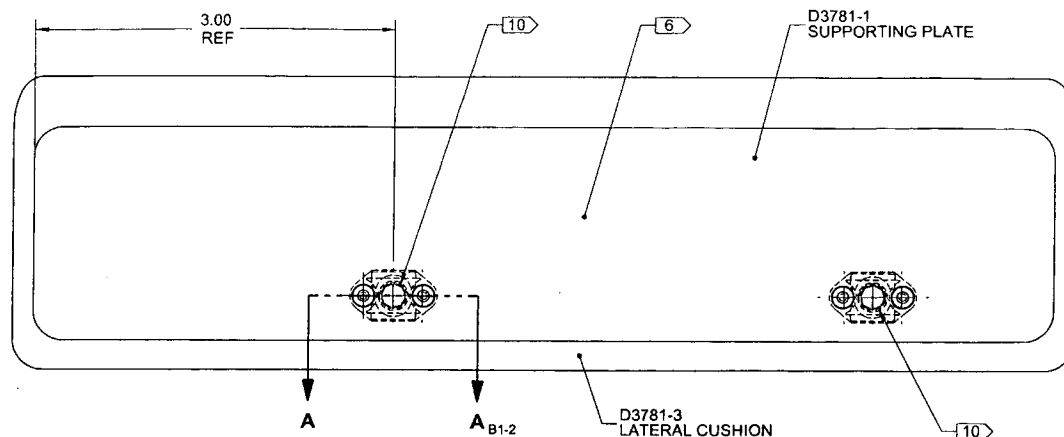
REV.	DESCRIPTION	BY	DATE
E	REMOVED ZIPPER FROM D3781-043. SHEET 3 REVISED ACCORDINGLY. REASON: MANUFACTURABILITY PER NCR 10-012.	MB	10.04.14
D	REDESIGNED BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.05.21
C	REDESIGNED FOR COMPATIBILITY WITH BHT 204 SEATS	MB	08.11.10
B	REDESIGNED; ADDED DETAIL A (ZN B7-1)	MB	08.07.15
A	NEW ISSUE	MB	08.04.29
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3781** REV. E
TITLE **CUSHION ASSEMBLY** SCALE NTS

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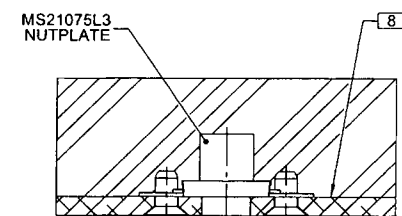
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3781-041	CUSHION ASSEMBLY
11	1	D3781-1	SUPPORTING PLATE
12	1	D3781-3	LATERAL CUSHION
22	2	MS21075L3	NUT PLATE (OR MS21075-3)
23	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY FABRIC
24	A/R	1300	3M SCOTCH-GRIP ADHESIVE
25	4	MS20426AD3-3	RIVET



D3781-041 LATERAL CUSHION ASSEMBLY
(UPHOLSTERY FABRIC NOT SHOWN FOR CLARITY)

D3781-041 NOTES:

- 1) MATERIAL: COVER D3781-1/-3 ASSEMBLY WITH SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
BOND FABRIC USING 3M 1300/1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.18 lbs
- 8) BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) IT IS ACCEPTABLE TO RELIEVE D3781-3 CUSHION WHERE THE NUTPLATES ARE LOCATED TO ENSURE PROPER CONTACT WITH D3781-1 SUPPORTING PLATE
- 10) HOLES MUST BE FREE OF ADHESIVE AND FABRIC



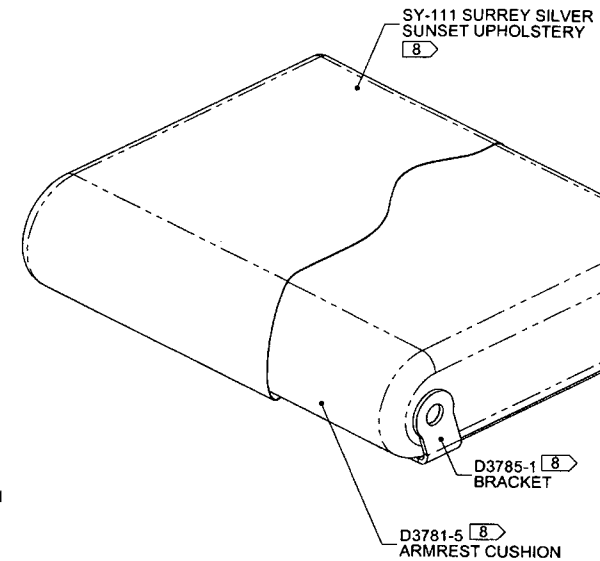
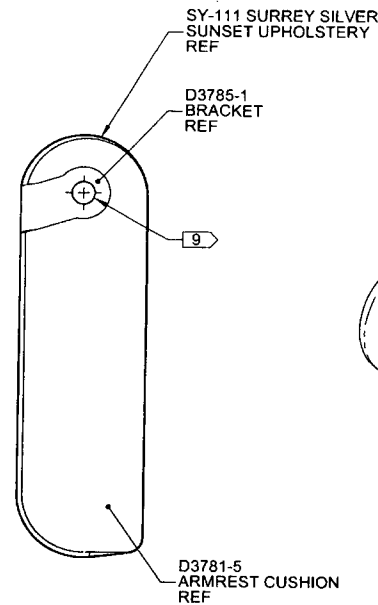
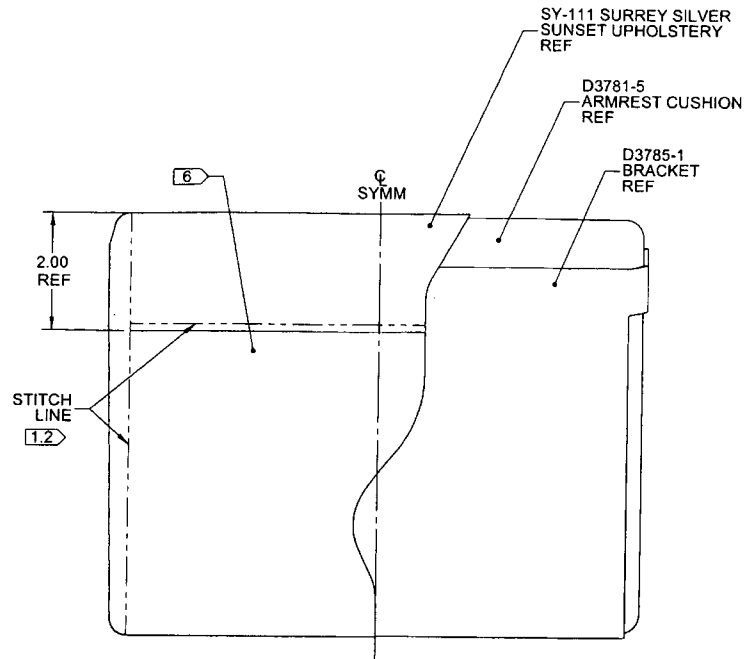
SECTION A-A
2 PL, SCALE 2X

RELEASED
2010-04-26

DESIGN	1	DART AEROSPACE LTD	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO. D3781	REV. E
MFG. APPR.	10		SHEET 2 OF 6
APPROVED	10	TITLE CUSHION ASSEMBLY	SCALE NTS
DE APPR.	10		
DATE	10.04.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D3781-043	ARMREST CUSHION ASSEMBLY
3	1	D3781-5	ARMREST CUSHION
4	1	D3785-1	BRACKET
6	A/R	SY-111	SURREY SILVER SUNSET UPHOLSTERY
7	A/R	1300	3M SCOTCH-GRIP ADHESIVE

03527



D3781-043 LATERAL ARMREST CUSHION BASE ASSY
(UPHOLSTERY FABRIC SHOWN PARTIALLY FOR CLARITY)

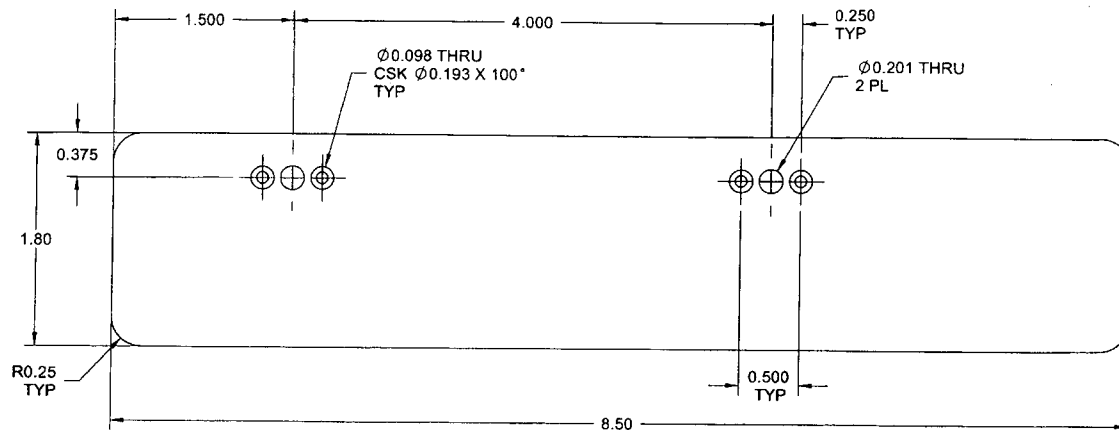
D3781-043 NOTES:

- 1) MATERIAL:
 - 1.1) SURREY SILVER SUNSET UPHOLSTERY FABRIC P/N SY-111.
 - 1.2) THREAD: MIL-VT-295 TYPE II CLASS A, GREY NYLON THREAD, 4-6 STITCHES PER INCH, USE 1/2" MIN BACKSTITCH, NO LOOSE THREADS
 - 1.3) ADHESIVE: 3M 1300/1300L
 - 1.4) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-043" USING FINE POINT PERMANENT INK MARKER AFTER RECEIVING
- 7) WEIGHT: 1.14 lbs
- 8) COVER D3781-5/D3785-1 ASSEMBLY WITH FABRIC (ITEM 6). BOND FABRIC TO PLATE USING ITEM 7 (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 9) DO NOT COVER HOLES WITH FABRIC

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3781	REV. E
MFG. APPR.			SHEET 3 OF 6
APPROVED		TITLE CUSHION ASSEMBLY	SCALE NTS
DE APPR.			
DATE	10.04.14		

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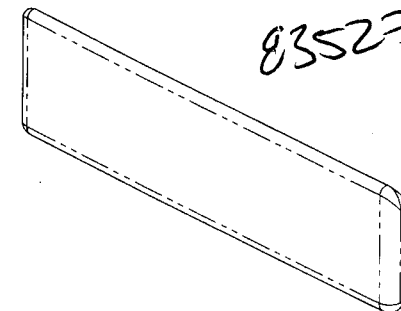
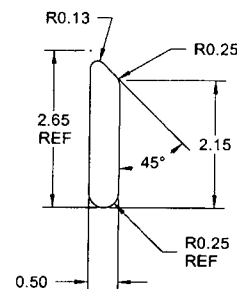
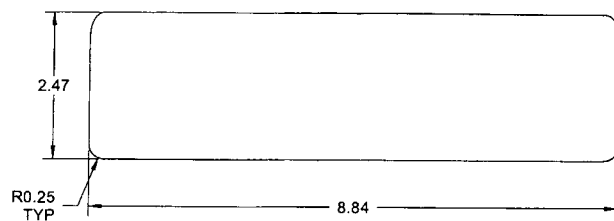
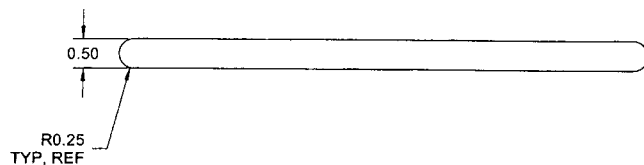
D3781-1 SUPPORTING PLATE

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3781	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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D3781-3 LATERAL CUSHION

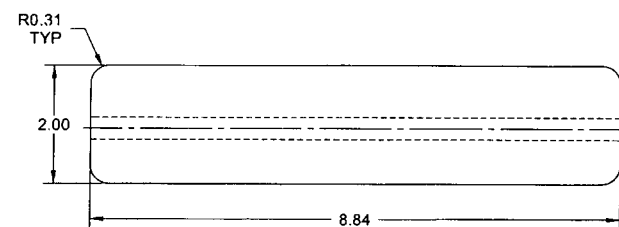
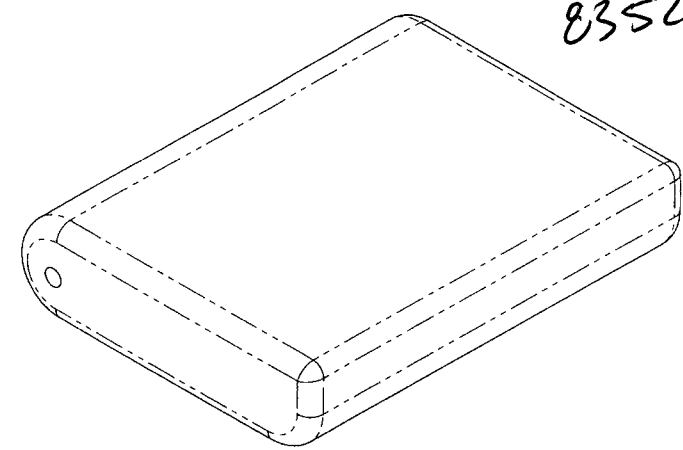
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2010-04-26
MD

D3781-3 NOTES:

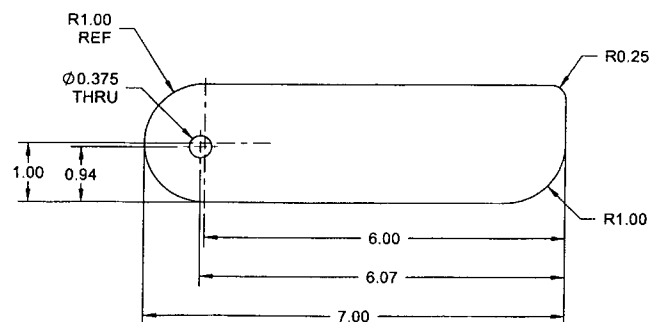
- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.08 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3781	SHEET 5 OF 6
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83527



D3781-5 ARMREST CUSHION



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2010-04-26
ND

D3781-5 NOTES:

- 1) MATERIAL: SKANDIA HR150 POLYFOAM (4.6 LBS/CU FT)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lbs
- 8) POSSIBLE SUPPLIER: AEROTEX INTERIORS INC.

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3781	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
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